

Work Order ID 57809 -2 *split*

Thursday, April 15, 2010 1:17:48 PM

Page 1

Item ID: D3909-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 4/15/2010 Start Qty: 6.00 *5*

Cust Item ID:

Required Date: 4/30/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

A B Memo 04.22

100

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

110

0.00

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
Trim rivet to 1.185" long

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8.06.07

EP 10/04/27 (5)

EP 10/04/27 (5)

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57809

Thursday, April 15, 2010 1:17:48 PM



Page 2

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 4/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 4/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 506

0.00

Memo

0.00

10-4-27

5x SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/28

mf
10-4-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 57809

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Comments: IPP RevA: New issue DD verified by:EC

Start Date: 4/15/2010

Required Date: 4/30/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2690-6

Manufactured

No

100

Each

19.0000

6.0000



Lanyard Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST021

19

50665

19

D3909-1

Manufactured

No

100

Each

6.0000

12.0000



Lug Plate, Fwd Crosstube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ENG

2

55704

2

Main Warehouse

ST095

4

57118

4

D3909-3

Manufactured

No

100

Each

2.0000

6.0000



Fwd Lower Attach Arm

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST095

2

56952

2

950/04/27

6
950/04/27
B57824 (8x)

4
950/04/27
B57819 (6x)

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 4/15/2010

Required Date: 4/30/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3909-5 		Manufactured	No			100	Each	0.0000	6.0000			
Eyebolt Stud												
D3910-1 		Manufactured	No			100	Each	12.0000	12.0000			
Crosstube Lug												

357820 (6x)

4/5/10/04/22



4/5/10/04/22

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse
ENG
57194

12
12

D3917-1

Manufactured No

100

Each

6.0000

12.0000



Washer



4/5/10/04/22

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse
ST096
57298

6
6

AN3C12A

Purchased No

100

Each

224.0000

24.0000



Bolts



4/5/10/04/22

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse
ST351
112314

224
224

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57809



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 4/15/2010

Required Date: 4/30/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C13 Bolt		Purchased	No			100	Each	44.0000	6.0000 		EP 10/04/22	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST351

44

114304

44

MS17984-C413

Purchased

No

100

Each

9.0000

6.0000



PIN, QUICK RELEASE

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST297

9

114340

9

MS20615-4M20

Purchased

No

100

Each

292.0000

18.0000



RIVET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST323

292

113254

16

114304

22

114324

54

114349

200

Thursday, April 15, 2010 1:17:48 PM

Shop Packet Print

Page 3

PTO

W/O: 57809		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/22		change MS20415-4M20 for MS20415-4M18 in 114349	EP	10/04/22	24 24	CP 10.04.22 per OS: 042	

Part No: D3909-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 57809



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 4/15/2010

Required Date: 4/30/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN310C3 Castellated Nut		Purchased	No			100	Each	44.0000	6.0000 		4/10/04/22	
<div><div><u>Warehouse</u> <u>Location</u> Main Warehouse ST349 114304</div><div><u>Loc Qty</u> 44 44</div><div><u>Loc Code</u></div></div>												
MS21043-3 Nut		Purchased	No			100	Each	3,875.000	24.0000 		4/10/04/22	
<div><div><u>Warehouse</u> <u>Location</u> OFFSHORE FG 103691 Main Warehouse ST301 112314</div><div><u>Loc Qty</u> 80 80 3795 3795</div><div><u>Loc Code</u></div></div>												
MS24665-151 Cotter Pin		Purchased	No			100	Each	716.0000	6.0000 		4/10/04/22	
<div><div><u>Warehouse</u> <u>Location</u> Main Warehouse ST309 17566</div><div><u>Loc Qty</u> 716 716</div><div><u>Loc Code</u></div></div>												

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Thursday, April 15, 2010 1:17:48 PM

Work Order ID: 57809



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 4/15/2010

Required Date: 4/30/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1149C0332R

Purchased

No

100

Each

5,196.000

60.0000



Washer



EP 10/04/22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST297

5196

113524

46

113737

150

114341

5000

60

NAS1149C0363 R

Washer

10.04.22

Qty: 12

Seq 100

Batch: 113422

(12x)

EP 10/04/22

** Was change on 10.04.20
as per Rev B.*

Thursday, April 15, 2010 1:17:48 PM

Shop Packet Print

Page 5

W/O: 57809		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/22	110 100	Miss Washer NAS 1149 C0343 R M 113422	JP	10/04/22	12	h	

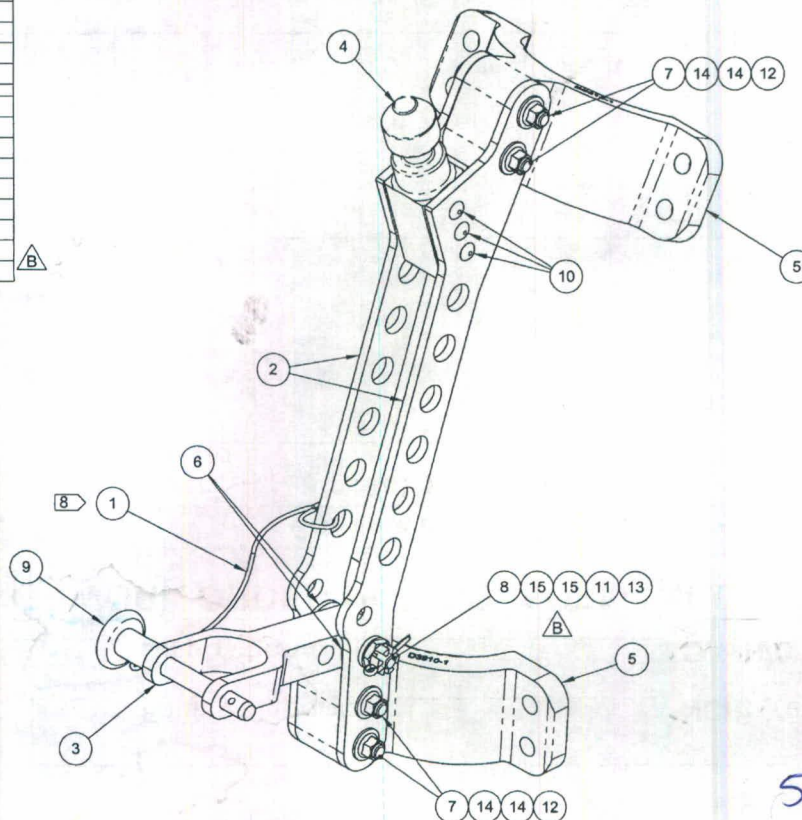
Part No: D3909-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

RELEASED
2010-04-07

57809

B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED; SECTION A-A & DIM 0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220. R0.06 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3909	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

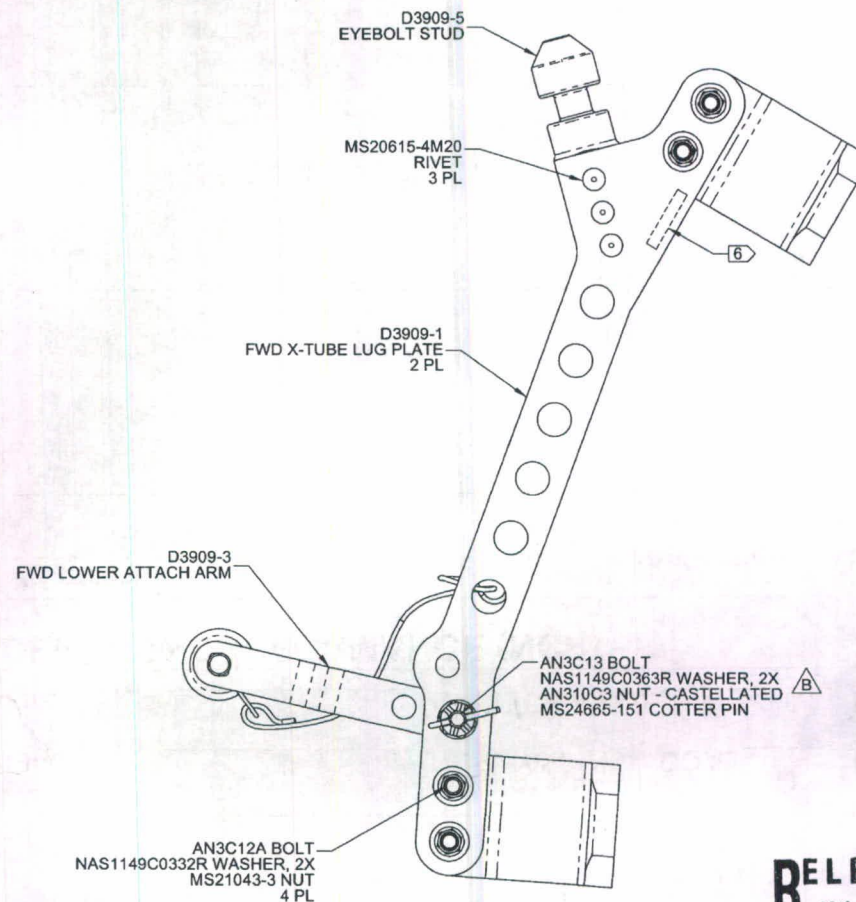
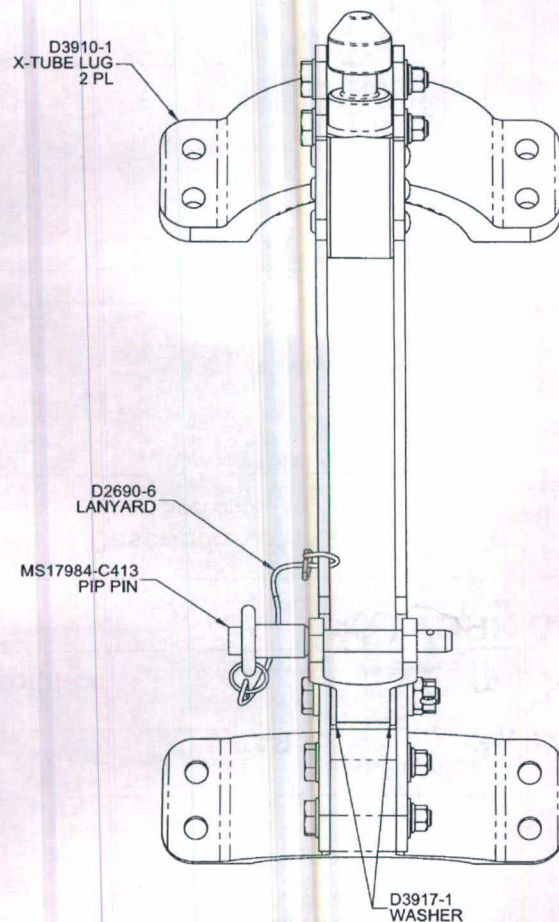
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-04-07
mp

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
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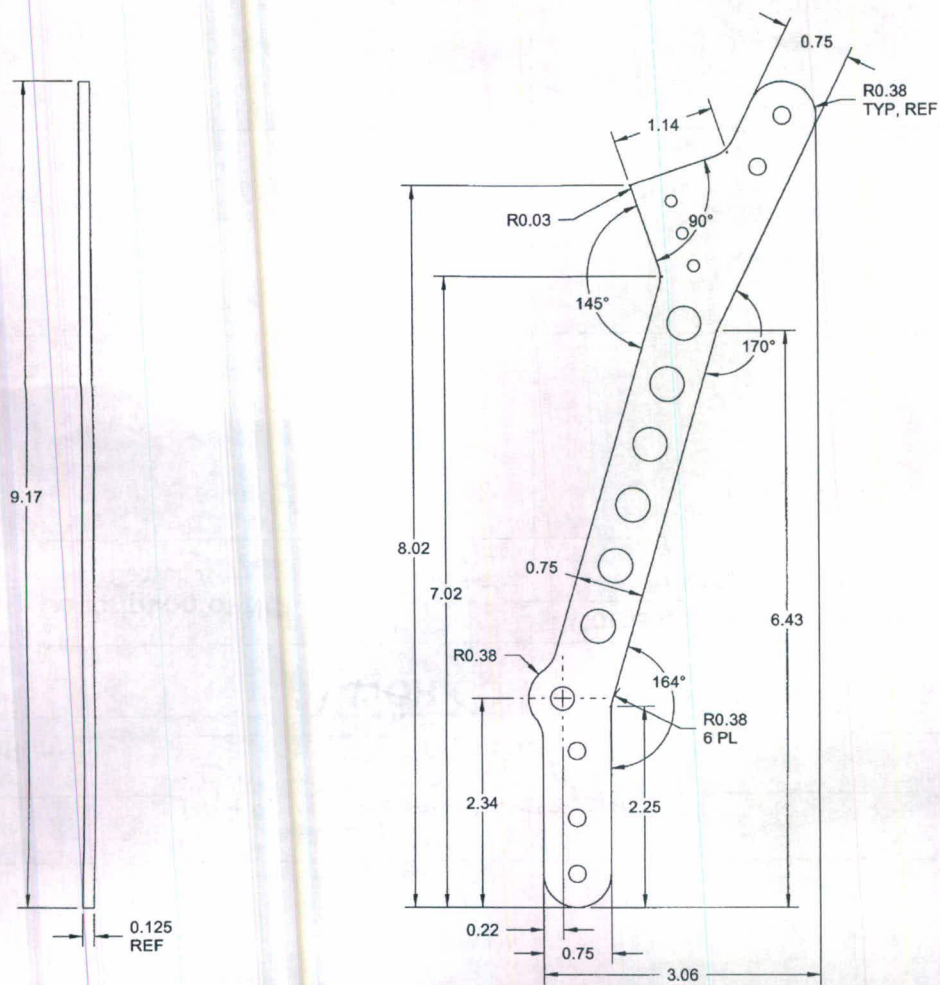
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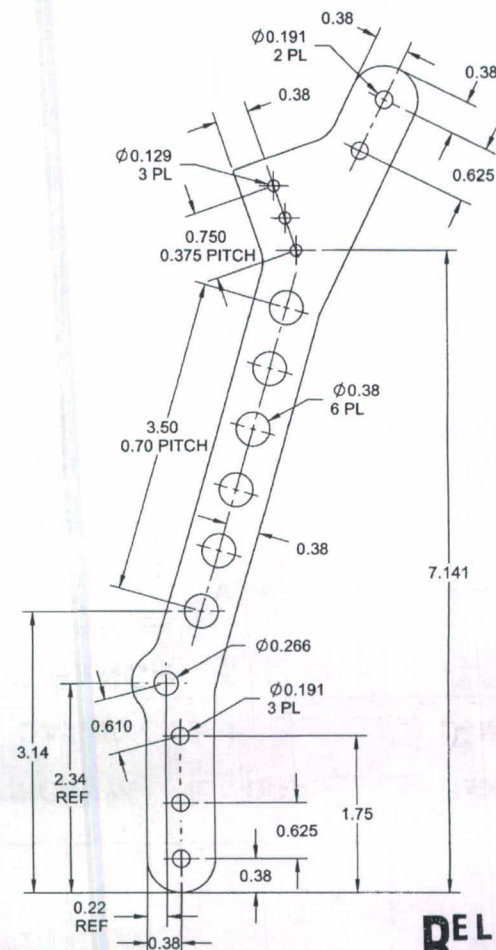
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NOTE: Date & initial all entries



D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

RELEASED
2010-04-07

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

57809

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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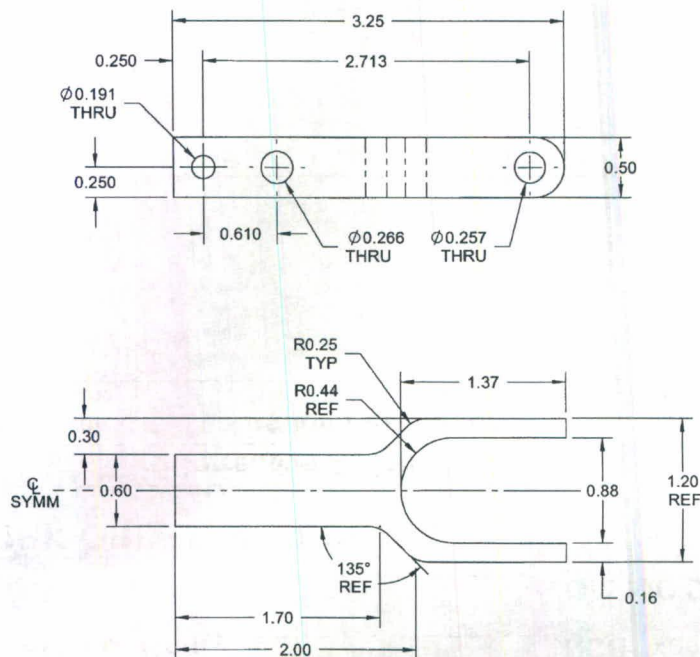
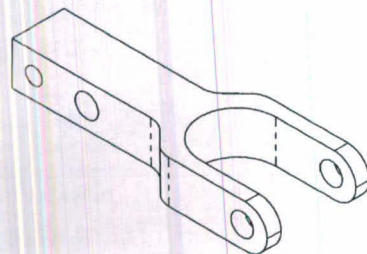
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3909-3 FWD LOWER ATTACH ARM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

57809

RELEASED
2010-04-07
MP

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3909	SHEET 4 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
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Date & initial all entries

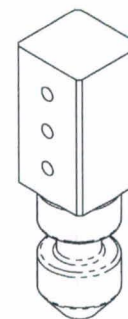
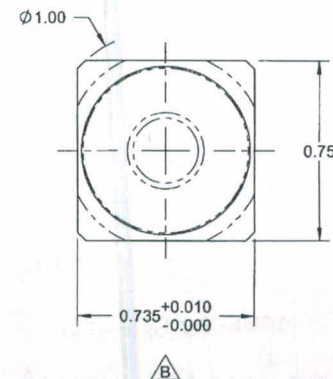
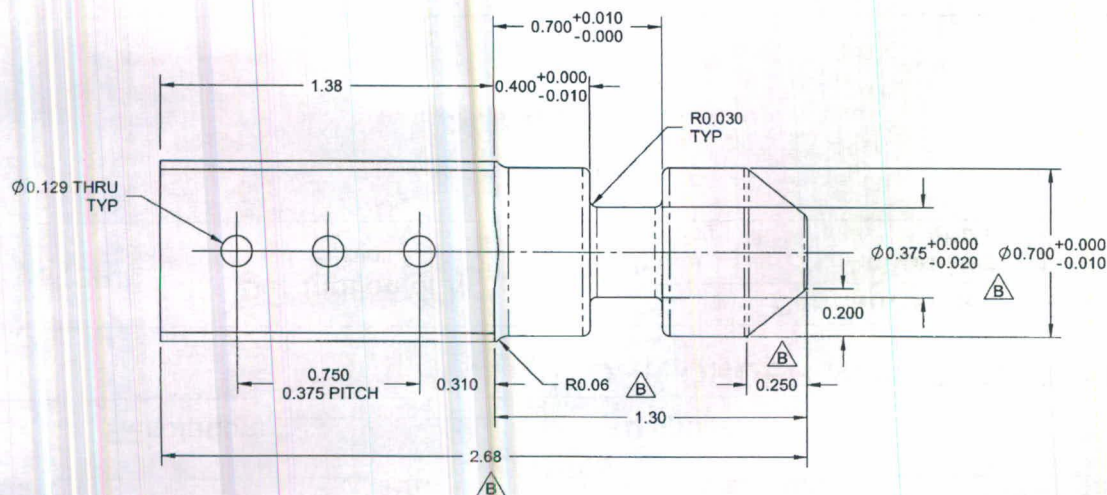
8 7 6 5 4 3 2 1

D

C

B

A



D3909-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-04-07
JMP

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3909	SHEET 5 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

ate & initial all entries